

20-8278



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D3368-041

Job Sheet 211905



Part No: D3368-041

Job Qty: 4 pcs

Part Name: Tail Rotor Pedal Lock



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/20

Job Tracking No:

Due Date: 8/14/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3368 REV B , D2690 REV B2 , D3384 REV C IPP Rev:A Removed from 9 Digit 06-03-22 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Lead Time	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier			
100	Small Fab - 1	4 pcs	8/14/20	8/14/20	0.00	9.36	Small Fab - 1		DAS 58 9-89	AUG 10 2020
							Small Fab - 2			
							Small Fab - 3			
							Small Fab - 4			
							Small Fab - 5			
							Small Fab - 6			
							Small Fab - 7			
							Small Fab - 8			
							Small Fab - 9			
							Small Fab - Various 1			
110	QC 5	4 pcs	8/14/20	8/14/20	0.00	0.00	QC 5 - 10		DAS 40 9-89	AUG 11 2020
							QC 5 - 12			
							QC 5 - 17			
							QC 5 - 18			
							QC 5 - 19			
							QC 5 - 22			
							QC 5 - 24			
							QC 5 - 3			
							QC 5 - 43			
							QC 5 - 49			
							QC 5 - 51			
							QC 5 - 58			
							QC 5 - 68			
							QC 5 - 9			
							QC 5 - 50			
							QC 5 - 30			
							QC 5 - 40			
							QC 5 - 61			
							QC 5 - 81			
							QC 5 - 82			
120	Packaging 3-1 - Stock - B4B	4 pcs	8/14/20	8/14/20	0.00	0.00	Packaging 3 - 1 - B4B			

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				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	AUG 12 2020
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
				130 QC 21 - SA	4 pcs
QC 21 - SA - 70	9-89				
QC 21 - SA - 9	AUG 12 2020				
QC 21 - SA - 77					

Part Op 100 - (Small Fab) 1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel.
Descriptions: Discard the rest. 2-Fabricate D3371-5 Cam Lock as per Dwg D3371 3- Cut cable to length as per dwg D2690 and D3384
4- Assemble lanyard to cyclic sock as per Dwg D3384 Identify as D3384-047 Identify as D3371-5 3-Assemble lock
mechanism and cam and install decal as per Dwg D3368.
110 - QC5- Inspect part completeness to step on W/O
120 - Identify as per dwg & Stock Location:
130 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
238-028 001	3/16" Dowel Pin .5" long	8 Ea (2 ea)	100-Small Fab - 1	S226094
385-039 581	8-32 Flat screw	16 Ea (4 ea)	100-Small Fab - 1	FM130688
CBL-1240	Cable	9.3320 ft (2.333 ea)	100-Small Fab - 1	3198126
CBL-460 005	Loop Sleeve	8 Ea (2 ea)	100-Small Fab - 1	S251780
D3368-1 495	Pedal Lock Base	4 pcs (1 ea)	100-Small Fab - 1	S262421
D3368-3 496	Pedal Lock Cover	4 pcs (1 ea)	100-Small Fab - 1	S261410
D3373-7 032F	Cam Lock	4 pcs (1 ea)	100-Small Fab - 1	S235809
D3384-1 500	Cyclic Sock	4 pcs (1 ea)	100-Small Fab - 1	S283813
D3385-3 033	Hinge	4 pcs (1 ea)	100-Small Fab - 1	S206332
HX-81 503	1/4"-20 SHCS 3/8" long	4 Ea (1 ea)	100-Small Fab - 1	S173615
NAS1149F0463P 000	Washer (AN960-416)	8 Ea (2 ea)	100-Small Fab - 1	S288

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	238-028	8	81	0
	385-039	16	20	0
	CBL-1240	9	181	0
	CBL-460	8	150	0
	D3368-1	4	4	0
	D3368-3	4	4	0
	D3373-7	4	7	0
	D3384-1	4	15	0
	D3385-3	4	10	0
	HX-81	4	22	0
	NAS1149F0463P	8	175	0

Part Specifications

Specifications could not be found.

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Container No: S293430



Part: D3368-041

Job No: 211905

Serial No/Batch: S293430

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 08/11/20

Entered: 78 Date: Aug 13/2020



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. 20-8278

Route update only ☐

Job: <u>211905</u> Part No. <u>D3368-041</u>		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☒		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☒ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier Quality ☐			
Date: <u>AUG 11 2020</u>		Sequence #: <u>100</u>		QTY Affected: <u>1</u>		MRB (QSI042)	
Description Work Order Deviation				Disposition		Completed By <u>DAS 58</u> <u>9-89</u> AUG 11 2020 Lead hand / Supervisor <u>DAS 40</u> <u>9-89</u> AUG 11 2020 QC / QA Coordinator <u>PD 20-08-11</u>	
<u>D3368-3 found out during assembly that one hole was dull opposite of the Aug QTI ①</u>				<u>acceptable per eng</u> <u>Does not affect fit form or function</u>			
Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☒ Incomplete/Unclear Instructions ☒ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					